

ASAP

Work Order ID 107122

107122

September-23-13 8:44:35 AM

Item ID: D4061-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ski Cushion
 Start Date: 9/23/13 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 9/24/13 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: *W* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4061	B								

100

0.00

100

Mill Conv

Conventional Milling Machine

Memo

1-Turn as per folio FA914 & dwg
 FOLIO REV: _____
 DWG REV: B

2-Deburr as required

0.00

DAS
40

13/10/07

20

Ø

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

DAS
40
9-89

13/10/07

20

Ø

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 08 9-89
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>ST 450</u>	0.00							
130									
Packaging	Memo 1X PPP 107116	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

[Signature] / Rm 13/10/08
 UNF
 13-10-08

Picklist Print

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Work Order ID: 107122

Parent Item: D40611

Parent Item Name: Ski Cushion

Start Date: 9/23/13

Required Date: 9/24/13

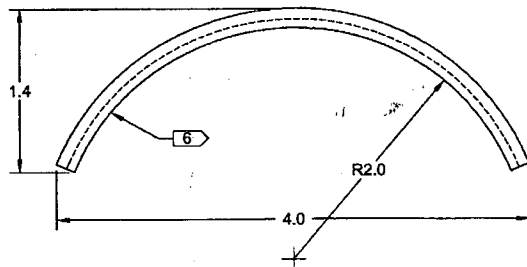
Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE JLM 10-02-18 VERIFIED BY:EC IPP REV:B 11.01.10 AS PER:
DWG REV.B DD VERF:EC

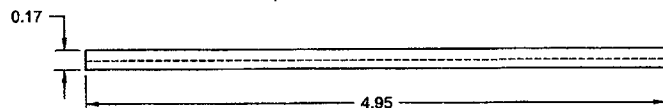
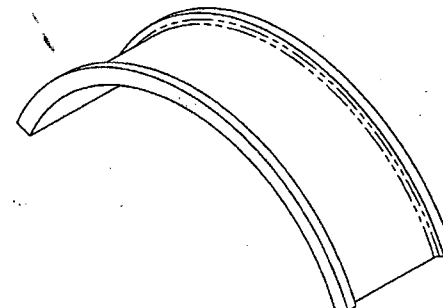
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3 Uhmw U-Channel		Manufactured	No			100	f	18.4000	0.4125	8.6842105			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST202		6.4							
				91102		6.4							
				ST209a		12							
				→ 97824		12				5.5			
				→ 81030						2.0			
				→ 107507						2.0			

DAS
40
8-89
13/10/07

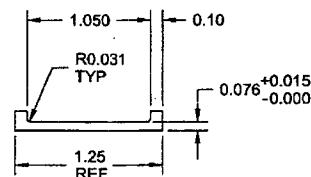


D4061-1 412 SKI CUSHION
(MAKE FROM D4061-1F)

no 107122



D4061-1F FLAT MACHINED STATE



RELEASED
2010-12-23
MR

NOTES:

- 1) MATERIAL: MAKE FROM D4287-3 **B**
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4061-1" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH ADEQUATE RADIUS. REF: PAR10-28.	MB	10.12.07
A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.12.07		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
DRAWING NO. D4061	SHEET 1 OF 1
TITLE 412 SKI CUSHION	SCALE NTS
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FIRST ARTICLE INSPECTION CHECKLIST

10.04.15